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Processing method of oil repellent agent of sleeve bearing for communication apparatus, involves forming layer of coating provided with color mixed oil repelling agent over internal bearing surface of sleeve

Patent Assignee: NIPPON SEIKO KK

Patent Family

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JP 2000266052	A	20000926	JP 9968292	A	19990315	200060	B

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Patent Details

Patent	Kind	Language	Page	Main IPC	Filing Notes
JP 2000266052	A		4	F16C 033/10	

Abstract:

JP 2000266052 A

NOVELTY The oil repelling agent is processed with a color additive and formed as a layer in the internal bearing surface of the sleeve (3).

DETAILED DESCRIPTION An **INDEPENDENT CLAIM** is also included for sleeve bearing.

USE For oil repellent agent of sleeve bearing for communication apparatus or spindle motor of acoustic and video equipment.

ADVANTAGE Identification of deficiency in layer of coating is enabled. Efficiency in formation of oil repellent layer is greatly improved.

DESCRIPTION OF DRAWING(S) The figure shows the schematic sectional view of the sleeve bearing.

Sleeve (3)

pp; 4 DwgNo 1/3

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POWERED BY **Dialog****Basic Patent (Number,Kind,Date): JP 2000266052 A2 20000926****PATENT FAMILY:****Japan (JP)**

Patent (Number,Kind,Date): JP 2000266052 A2 20000926

**PROCESSING METHOD FOR OIL REPELLENT AGENT OF FLUID BEARING DEVICE
AND FLUID BEARING DEVICE USING THE OIL REPELLENT AGENT (English)**

Patent Assignee: NSK LTD

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**PROCESSING METHOD FOR OIL REPELLENT AGENT OF FLUID BEARING DEVICE AND
FLUID BEARING DEVICE USING THE OIL REPELLENT AGENT (2000-266052
Publication Number: JP 2000266052 A) , September 26, 2000**

Inventors:

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Application Number: 11-068292 (JP 9968292) , March 15, 1999

International Class:

- F16C-033/10
- F16C-017/02

Abstract:

PROBLEM TO BE SOLVED: To visually confirm the coated condition in the oil repellent finishing onto a fluid bearing device by adding a coloring agent into the oil repellent agent.
SOLUTION: The water repellent finishing is executed only on an outer peripheral surface 15 of a shaft 1, a taper part 11 of a sleeve member 3, and an opening end 9 positioned in a zone indicated by a broken line. The fluorescent coloring agent, pigment and the like is added to the used oil repellent agent. When the oil repellent finishing is executed by using the oil repellent agent including the coloring agent, a part coated with the oil repellent agent can be visually confirmed, so that a mistake that an unfinished product is sent to a next process, can be prevented. Further, a mistake that a thick layer of the oil repellent agent is formed on a fine part of the member to be coated, can be prevented, and the oil repellent finishing efficiency can be remarkably improved. According to this oil repellent finishing method, the coated area can be visually confirmed during the coating of the oil repellent agent. COPYRIGHT: (C) 2000,JPO

JAPIO

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[Detailed Description of the Invention]

[0001]

[The technical field to which invention belongs] Especially this invention relates to the oil-repellent processing for preventing defluxion of a lubricous fluid in bearing of the hydrodynamic bearing equipment which has a dynamic pressure slot at least in one of the two of a shaft or a sleeve about liquid bearing equipment and the liquid bearing equipment used for the spindle motor for information machines and equipment and audiovisual equipments in more detail.

[0002]

[Description of the Prior Art] it is shown in drawing 3 -- as -- the former -- a sleeve -- a member 103 and a sleeve -- a member 103 -- receiving -- relative -- the shank material 101 which can rotate freely -- having -- a sleeve -- the radial side dynamic pressure generating slot 107 prepares in either the inner skin of a member 103, and the periphery side of the shank material 101 -- having -- the shank material 101 and a sleeve -- the liquid bearing equipment 100 with which the gap 115 and the dynamic pressure generating slot 107 between members 103 are filled

[0003] In order that lubricous fluids, such as an oil with which the gap 115 formed by the periphery side of a shaft 101 and the inner skin of a sleeve 103 was filled up, might prevent leaking with the centrifugal force generated by rotation, oil-repellent processing had been performed using the transparent and colorless oil repellent agent. after [moreover,] usually diluting an oil repellent agent with the process of oil-repellent processing using an volatile high diluent in order to apply an oil repellent agent thinly and uniformly -- the radial bearing section 113 or a sleeve -- the oil repellent agent was applied to a periphery called the end face 109 and the taper section 111 of a member 103

[0004]

[Problem(s) to be Solved by the Invention] However, the conventional oil-repellent art has the following troubles. - the case where an oil repellent agent is applied to the place which must not be applied, and coated -- when applying to a portion with a detailed member, since the oil repellent agent is transparent and colorless, it is difficult to check the existence of an application with the naked eye - the liquid of the case where an oil repellent agent is applied in large quantities, or its oil repellent agent -- the case where who etc. arises -- since the oil repellent agent is transparent and colorless -- coated -- a member -- it is difficult whether the oil repellent agent was applied by the throat top, and to distinguish - Since [that volatility is high] the diluent usually used for the top where an oil repellent agent is transparent and colorless in order to dilute has early evaporation, when the oil repellent agent diluted with the cotton swab etc. is applied, it makes the check of the existence of an application difficulty further.

[0005]

[Means for Solving the Problem] In order to solve the above-mentioned trouble, suppose that a color coupler adds this invention to the aforementioned oil repellent agent in the art of the oil repellent agent which forms the layer of an oil repellent agent in liquid bearing equipment. When performing oil-repellent processing by this invention to liquid bearing equipment, the state where it was applied can be checked with the naked eye.

[0006]

[Embodiments of the Invention] In the oil-repellent processing for preventing defluxion of a lubricous fluid in bearing of the liquid bearing equipment which has a dynamic pressure slot at

least in one of the two of a shaft or a sleeve, the oil repellent agent by which the color coupler was added is used for this invention.

[0007] What contains the thing or color which has fluorescence nature as a color coupler is used. In addition, when using the oil repellent agent which mixed the material of fluorescence nature, it is desirable to do application work under an ultraviolet linear light.

[0008]

[Example] Hereafter, the example of this invention is explained in detail, referring to an accompanying drawing. In addition, in the drawing, the same sign has shown the same portion. Moreover, although the portion to which an oil repellent agent is applied is shown in layers by the dashed line, it does not limit the amount and thickness of an oil repellent agent which should be applied.

[0009] Drawing 1 is the cross section showing the fundamental composition of the liquid bearing equipment by this invention. the composition of the conventional example which mentioned this composition above -- almost -- the same -- liquid bearing equipment 10 -- a cylinder-like sleeve - a member 3 and a sleeve -- the shank material 1 inserted in free [rotation] to the member 3 -- since -- it becomes

[0010] moreover, a sleeve -- it passes to the inner skin 13 of a member 3, the radial side dynamic pressure generating slot 17 of a ring bone configuration is established in it, and lubricant is injected into the slot 17 furthermore, a sleeve -- the radial side dynamic pressure generating slot 17 is adjoined, and the taper section 11 to which the path of inner skin 13 becomes large is formed in the release edge inner skin of a member 3 as it keeps away from the radial side dynamic pressure generating slot 17 This taper section 11 is also filled up with lubricant.

[0011] In case liquid bearing equipment [like] 10 is assembled like this, in order to prevent lubricous fluids, such as an oil, leaking from the inside of bearing, an oil repellent agent is applied to the front face of bearing material, and the layer of an oil repellent agent is formed in the front face of bearing material.

[0012] the periphery side 15 of a shaft 1 which is the part shown in the dashed line section in the 1st example, and a sleeve -- oil-repellent processing has been performed only to the taper section 11 and the release edge 9 of a member 3 A color coupler or a color of fluorescence nature etc. is added by the oil repellent agent used.

[0013] If oil-repellent processing is performed using the oil repellent agent by which the color coupler was added, since the portion to which the oil repellent agent was applied can be checked with the naked eye, mistake of pouring an unsettled article at the following process can be prevented.

[0014] moreover, coated -- mistake of applying the layer of an oil repellent agent to the detailed section of a member thickly can be prevented, and the working efficiency of oil-repellent processing improves by leaps and bounds

[0015] Furthermore, in the oil-repellent art by this invention, the applied portion can check with the naked eye, applying an oil repellent agent.

[0016] Drawing 2 is the cross section showing the liquid bearing equipment 10 by the 2nd example of this invention, and since the element which constitutes liquid bearing equipment 20 is almost the same as drawing 1 , it omits explanation.

[0017] in the 2nd example, the dashed line section shows a different point from the 1st example - as -- a sleeve -- it is carrying out oil-repellent processing to the whole surface including the

taper section 31 of a member 23, the radial side shaft receiving part 33, and the release edge 29, and the periphery side 25 of a shaft 21 Since what is necessary is just to immerse an entire component in an oil repellent agent if it does in this way, an application becomes easy. A color coupler or a color of fluorescence nature etc. is added by the oil repellent agent like the 1st example.

[0018] In the 2nd example by the oil-repellent art of this invention, the same effect as the 1st example is acquired.

[0019] Furthermore, since the oil repellent agent is colored when performing oil-repellent processing into the slot for dynamic pressure generating established in the inner skin of a sleeve, compared with the conventional oil-repellent art, the check of an application with a naked eye becomes easy.

[0020] In addition, the portion which performs oil-repellent processing in the oil-repellent art by this invention is not limited to the portion which performs oil-repellent processing in the 1st and 2nd examples.

[0021] Moreover, in order to raise the adhesion of an oil-repellent film if needed, it may heat-treat, after applying an oil repellent agent.

[0022]

[Effect of the Invention] It becomes possible to distinguish the existence, the nonuniformity, and the non-applying section of an application of an oil repellent agent with the naked eye by adopting the colored oil repellent agent like the oil-repellent art of this invention. moreover, coated -- when oil-repellent processing to the detailed section of a member was performed, the check became easy and the efficiency of the oil-repellent processing work for forming the layer of an oil repellent agent improved by leaps and bounds

[Translation done.]

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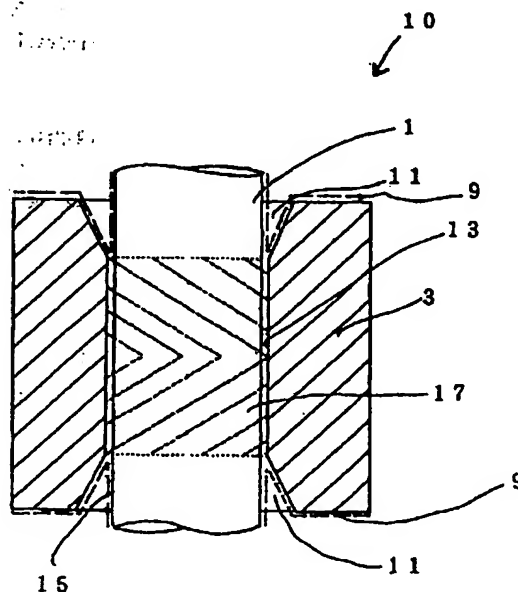
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(54) 【発明の名称】 流体軸受装置の撥油剤の処理方法及びその撥油剤を使用した流体軸受装置

(57) 【要約】

【課題】 撥油処理を流体軸受装置に行う場合、撥油剤が無色透明であるため、被塗布部材への塗布の有無について肉眼で確認することが困難である。

【解決手段】 流体軸受装置に撥油剤の層を形成する撥油剤の処理方法において、前記撥油剤に発色剤が添加されていることを特徴とする流体軸受装置の撥油剤の処理方法。



【特許請求の範囲】

【請求項1】 流体軸受装置に撥油剤の層を形成する撥油剤の処理方法において、前記撥油剤に発色剤が添加されていることを特徴とする流体軸受装置の撥油剤の処理方法。

【請求項2】 流体軸受装置において、発色剤を添加した撥油剤の層が形成されている流体軸受装置。

【発明の詳細な説明】

【0001】

【発明の属する技術分野】本発明は流体軸受装置、更に詳しくは情報機器、音響・映像機器用スピンドルモータに用いられる流体軸受装置に関し、特に、軸又はスリーブの少なくとも片方に動圧溝を持つ動圧軸受装置の軸受部において潤滑流体の流出を防止するための撥油処理に関する。

【0002】

【従来の技術】図3に示されるように、従来よりスリーブ部材103と、スリーブ部材103に対して相対的に回転自在である軸部材101とを備え、スリーブ部材103の内周面および軸部材101の外周面のいずれか一方には、ラジアル側動圧発生溝107が設けられ、軸部材101とスリーブ部材103との間の隙隙115及び動圧発生溝107に潤滑流体が充填されている流体軸受装置100が使用されている。

【0003】軸101の外周面とスリーブ103の内周面とで画成される隙隙115に充填された油等の潤滑流体が、回転により発生する遠心力等により漏れることを防止する為に、無色透明の撥油剤を使用して撥油処理を施していた。また、撥油処理の工程では、撥油剤を薄くかつ均一に塗布する目的で、通常揮発性の高い希釈剤を用いて撥油剤を希釈した後、ラジアル軸受部113又は、スリーブ部材103の端面109およびテーパー部111といった周辺部に撥油剤が塗布されていた。

【0004】

【発明が解決しようとする課題】しかしながら、従来の撥油処理方法は、つぎのような問題点がある。・塗布してはいけない場所に撥油剤が塗布された場合や、被塗布部材の微細な部分へ塗布する場合に、撥油剤が無色透明であるため、塗布の有無を肉眼で確認することが困難である。・撥油剤が大量に塗布された場合やその撥油剤の液だれ等が生じた場合に、撥油剤が無色透明であるため、被塗布部材のどこまで撥油剤が塗布されたか判別することが困難である。・撥油剤が無色透明である上に、希釈するために通常使用される希釈剤は、揮発性が高く蒸発が早いため、綿棒などで希釈された撥油剤を塗布した場合に、塗布の有無の確認を一層困難にしている。

【0005】

【課題を解決する手段】上記問題点を解決するために、本発明は、流体軸受装置に撥油剤の層を形成する撥油剤の処理方法において、前記撥油剤に発色剤が添加するこ

ととしている。本発明による撥油処理を流体軸受装置に行う場合、塗布された状態を肉眼で確認できる。

【0006】

【発明の実施の形態】本発明は、軸又はスリーブの少なくとも片方に動圧溝を持つ流体軸受装置の軸受部における、潤滑流体の流出を防止するための撥油処理において、発色剤が添加された撥油剤を使用するものである。

【0007】発色剤としては、蛍光性を有するもの又は染料を含有するものを用いる。なお、蛍光性の材料を混ぜた撥油剤を使用する場合には、紫外線光のもとで塗布作業を行うことが好ましい。

【0008】

【実施例】以下、添付図面を参照しつつ本発明の実施例を詳細に説明する。尚、図面において同一部分は同一符号で示してある。また、撥油剤が塗布される部分は、破線で層状に示されているが、塗布すべき撥油剤の量および厚さを限定するものではない。

【0009】図1は、本発明による流体軸受装置の基本的な構成を示す断面図である。この構成は前述した従来例の構成とほぼ同じであり、流体軸受装置10は、円筒状のスリーブ部材3と、スリーブ部材3に対して回転自在に嵌め合わせられた軸部材1と、からなる。

【0010】また、スリーブ部材3の内周面13には、ヘリングボーン形状のラジアル側動圧発生溝17が設けられ、溝17には、潤滑剤が注入されている。更に、スリーブ部材3の解放端部内周面には、ラジアル側動圧発生溝17に隣接して、ラジアル側動圧発生溝17から遠ざかるにつれて内周面13の径が大きくなるようなテーパー部11が設けられている。このテーパー部11にも、潤滑剤が充填されている。

【0011】このような流体軸受装置10を組み立てる際、軸受内から油等の潤滑流体が漏れることを防ぐ為に、撥油剤を軸受部材の表面に塗布して、軸受部材の表面に撥油剤の層を形成する。

【0012】第1実施例では、破線部で示した部位である、軸1の外周面15、スリーブ部材3のテーパー部11及び解放端部9のみに、撥油処理を施してある。使用される撥油剤には、蛍光性の発色剤又は染料等が添加されている。

【0013】発色剤が添加された撥油剤を用いて、撥油処理を行うと、撥油剤が塗布された部分を肉眼で確認できるので、未処理品を次工程に流すといったミスを防止する事が出来る。

【0014】また、被塗布部材の微細部へ撥油剤の層を厚く塗布してしまうというミスを防止でき、撥油処理の作業効率が飛躍的に向上する。

【0015】さらに、本発明による撥油処理方法では、撥油剤の塗布を行いながら、塗布された部分が肉眼で確認できる。

【0016】図2は本発明の第2実施例による流体軸受

＊【発明の効果】本発明の撥油処理方法のように、着色された撥油剤を採用することによって、撥油剤の塗布の有無やムラ及び非塗布部を肉眼で判別することが可能となる。また、被塗布部材の微細部への撥油処理を行う場合にも、その確認が容易となり、撥油剤の層を形成するための撥油処理作業の効率が飛躍的に向上した。

【図１】図１は、本発明の撥油処理方法の第１実施例である撥油処理が行われた流体軸受装置を示す概略断面図である。

【図２】図２は、本発明の撥油処理方法の第２実施例である撥油処理が行われた流体軸受装置を示す概略断面図である。

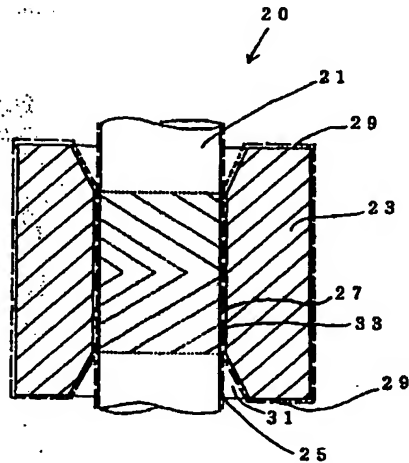
【図3】図3は、従来の艀油処理方法の艀油処理が行われた流体軸受装置を示す概略断面図である。

【符号の説明】

1、21	軸
3、23	スリーブ
9、29	スリーブ端面
11、31	テーバー部
17、27	動圧発生溝
25	軸の外周面

20

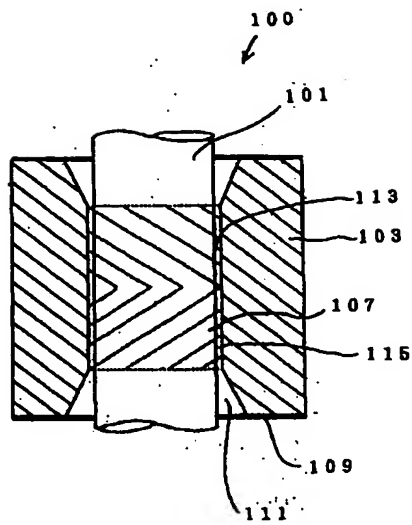
【図2】



(4)

特開2000-266052

【図3】



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